

1. A improved tooling fabrication method, comprising the steps of:
- 2 depositing a first metallic or ceramic alloy using a laser-assisted direct metal  
deposition process in a first region of the tooling requiring high thermal or wear  
4 resistance; and
- 6 depositing a second metallic or ceramic alloy using a laser-assisted direct metal  
deposition process in a second area of the tooling requiring high strength or impact  
resistance.

2. The method of claim 1, wherein the tooling is used in injection molding,  
2 die casting, or thixomolding.

3. The method of claim 1, wherein:
- 2 the tooling includes a gate area; and
- the first metallic or ceramic alloy is deposited relative to the gate area.

4. The method of claim 1, wherein:
- 2 the tooling includes in interface associated with opening and closing; and
- the second metallic or ceramic alloy is deposited relative to interface.

5. The method of claim 1, wherein:
- 2 the tooling is die-cast mold having a gate area;
- H19 steel is used in conjunction with the fabrication of the gate area; and

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- 4            H13 steel is used in conjunction with the fabrication of non-gate areas.